

Hempel's Conversion Primer

Product characteristics

Description

Hempel's Conversion Primer is a two-component epoxy to enable easy conversion from antifouling to Hempel's advanced biocide-free fouling protection. Can be applied on previously painted antifouling in good condition.

Recommended use

For use as a conversion primer over antifouling to secure adhesion of Hempel's biocide-free products. Use as a tiecoat between an epoxy primed surface and Hempaspeed TF.

Product safety

Flash point 31°C [88°F]

VOC content mixed product

Legislation	Value
EU	541 g/L [4.51 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website.

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

Product data

Product code

45441

Product components

Base 45445

Curing Agent 95441

Standard shade / code

Light pink 50711

Gloss

Flat

Volume solids

36 ± 2%

Specific gravity

1.2 kg/L [10 lb/US gal]

Reference dry film thickness

25 micron [1.0 mils]

Surface preparation

Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.

New build:

- Not for uncoated surfaces.
- Uncoated surface: Prepare bare substrates according to Hempel's primer instruction.

Maintenance and Repair

- Previously coated surface: Use a metal scraper to determine whether the aged antifouling adheres sufficiently. In case of bad adhesion, remove all loose/brittle layers.
- Abrade with wet abrasive paper.
- Rinse the surface with fresh water.
- Clean and dry the surface.
- Areas with filler to be sealed with primer/sealer.

Hempel's Conversion Primer

Application

Mixing ratio

Base 45445 : Curing Agent 95441
(3 : 1 by volume)

Thinner

No thinning

Cleaner

Hempel's Thinner 845 08451

Pot life

Product temperature	20°C [68°F]
Pot life	8 hours

Application method

Tool	Thinning max vol.	Application parameters
Brush/Roller	No thinning	Not Applicable.

Do not dilute the components separately - only the mixture.

Film thickness

	Recommended
Dry film thickness	25 micron [1.0 mils]
Wet film thickness	69 micron [2.7 mils]
Theoretical spreading rate	15 m²/L [611 sq ft/US gal]

Application conditions

- Surface temperature must be above 10°C [50°F] during application and curing.

Relative Humidity:

- Relative humidity must be below 85% during drying and curing.

Application remarks

- Previously coated surface: Apply 1 full coat undiluted.
- Be aware that the product has a very low viscosity and any runs and sags should be brushed out immediately.
- Overcoat with Hempel's advanced biocide free fouling protection products.

Drying and overcoating

Product compatibility

- Subsequent coat: Recommended products are: Hempel's Silic One Tiecoat, Hempaspeed TF

Drying time

Surface temperature		10°C [50°F]	20°C [68°F]	30°C [86°F]
Hard dry	hours	2½	1¼	½
Ready to sand	hours	-	2	-
Fully cured	days	14	7	4

Determined for dry film thickness 25 micron [1.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		10°C [50°F]	20°C [68°F]	30°C [86°F]
Immersion				
Hempel's Silic One Tiecoat 27450	Min	4 h	2 h	60 min
	Max	8 h	4 h	2 h
Hempaspeed TF	Min	30 min	30 min	30 min
	Max	65 min	65 min	65 min

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.
- Condensation on the freshly applied coating should be avoided.

Hempel's Conversion Primer

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Other remarks

- The surface must be clean before overcoating.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	36 months
Curing Agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Storage conditions

- The curing agent is sensitive to moisture. Store in a dry place and keep the can tightly closed until use.
- Temperature must not go below 5°C [41°F] during transport and storage.

Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	13.8 g CO ₂ e/m ²	0.072 lb CO ₂ e/ft ²

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- Further information: Hempel Yacht Paint Manual and hempelyacht.com

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.